

Work Order ID 80047***80047***

Page 1

Thursday, February 09, 2012 11:21:22 AM

Item ID: D4055-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tank Upper Cut Out

Start Date: 2/10/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *NLF*Date: *12-02-09*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4055

B

100

0.00

100

Purchasing

Memo

0.00

Purchasing

14157
Issue P/O:
Purchase part as per Dwg D4055
Possible Supplier: GFI
Material release note required*112027*
4

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

6443/5 (4)

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

*81716766**(44)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

4XJ M-12/03/06

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

4 R 123-6

150

Identify as per dwg & Stock Location WA

0.00

150

Packaging

Memo

0.00

Packaging

12/3/7 SP 4

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 12/03/07

MLJ 12/03/07
4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 1

Thursday, February 09, 2012 11:21:22 AM

Work Order ID: 80047

Parent Item: D4055-5

Start Date: 2/10/2012

Required Date: 2/24/2012

Parent Item Name: Tank Upper Cut Out

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4055-5P Tank Upper Cut Out		Purchased	No			110	Each	0.0000	1	4		6/4/3/5 (4)	

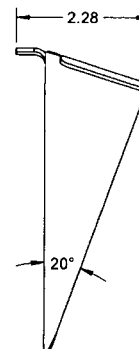
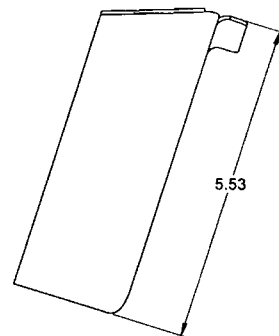
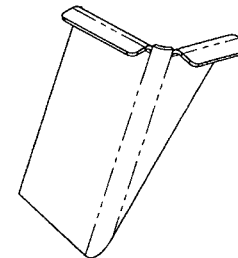
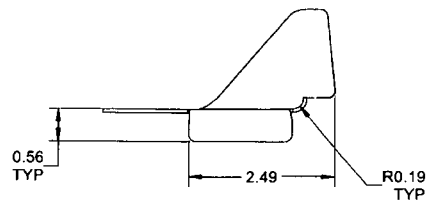
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NOTE: Date & initial all entries



80047

RELEASED
2011-05-30
NW

D4055-5 UPPER CUT OUT

NOTES:

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 8 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

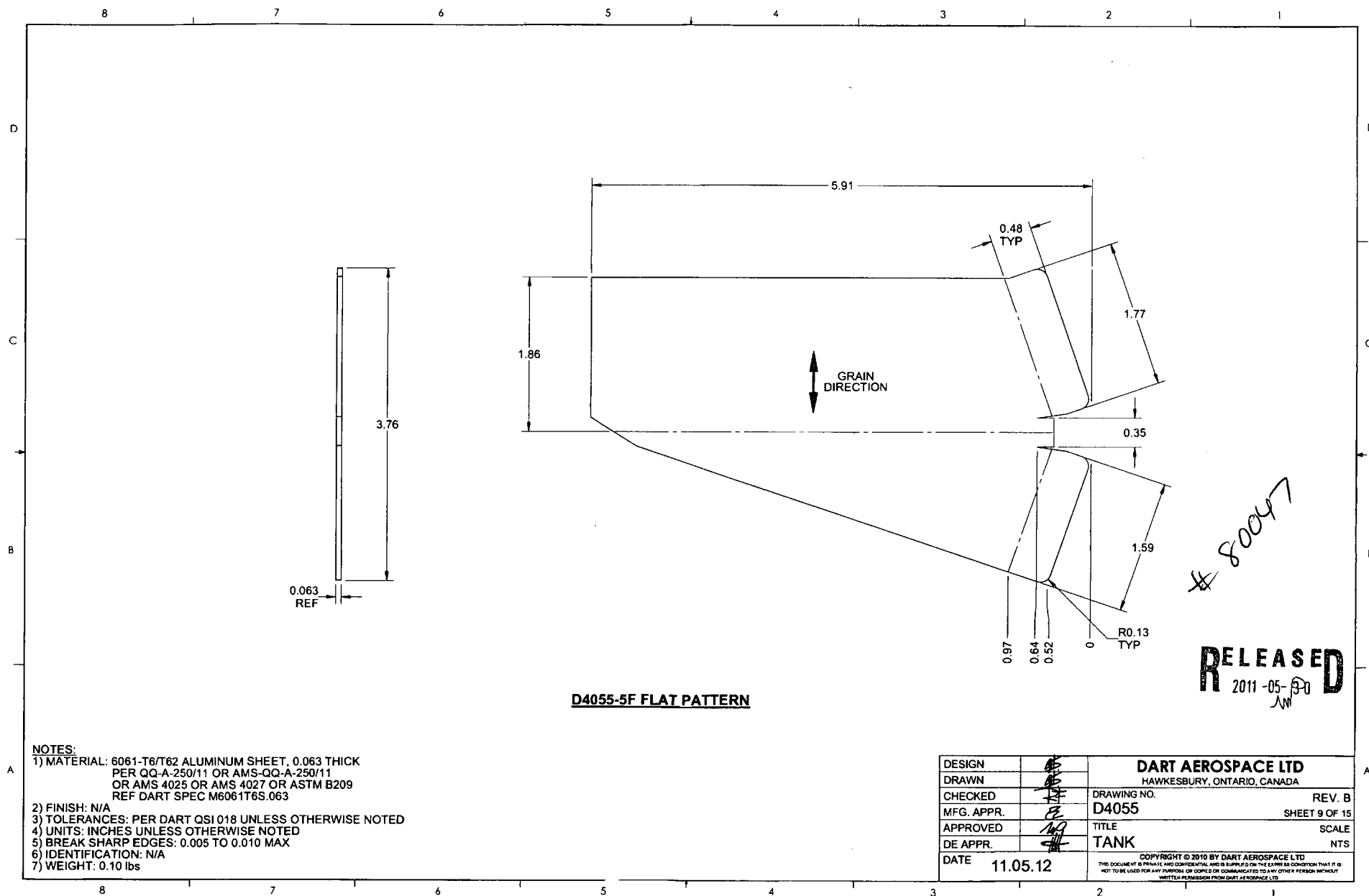
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NOTE: Date & initial all entries



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NOTE: Date & initial all entries



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON / SHIPPING MEMO NO.	PAGE
JR - DY	MO - MO	AN - YR		
02	03	12	0482085	1/1



ENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE		N° DE CONTRAT / JOB NO.	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR / SHIP VIA				
DART GFI-0299		0245063	PO16157					
QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO.		DESCRIPTION					
4	D405275P		TANK UPPER CUT OUT					
			CERTIFICATE OF CONFORMANCE REQ					
MFG. JOB# 50245063-001 QTY 4								
EXPÉDITEUR / SHIPPER				N° DE BON DE LIVRAISON / SHIPPING MEMO NO.				



REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	<u>8</u>	OUR JOB NO	<u>J0245063</u>	SHIPPING MEMO	<u>0482085</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>---</u>	<u>4 PCS</u>	<u>PO16157</u>	<u>D4055-5P</u>	<u>B</u>	<u>TANK UPPER CUT OUT</u>	<u>B</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>.063 THK AL 6061-T6 (AMS-QQ-A-250/11)</u>		<u>SAMUEL / ALCOA INC</u>		<u>719924</u>		
PROCESS		PROCESSOR		RELEASE NOTE #		
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>		<u>GFI</u>	<u>N/A</u>		
2	<u>REF. GFI MANUFACTURING JOB NUMBER J0245063-001 (4 PCS)</u>					
3						
4						
5						
6						
7						
8						
9						

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 02 MARCH 2012

G.F.I. Q.C. REP.

B. Samiee





Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2008 + AS9100B

LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Date: October 28, 2011

Company Name: GFI Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe-Claire, Qc
Zip Code: H9R 1A1

du client: 0079443
Customer's order #:

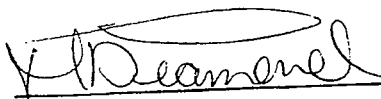
de commande SSMQ: 105044
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
01	2	.063" X 48" X 144"	6061 T6	AMS-QQ-A-250/11 AMS 4027	719924

Bien à vous,
Yours truly,





5-12/09/10

LES MÉTAUX SPÉCIALISÉS SAMUEL, 21525 CLARK-GRAHAM, BAIE d'URFÉ, QUÉBEC H9X 3T5
SAMUEL SPECIALITY METALS, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5

TÉL: 514-457-3399
FAX: 514-457-9393

LET. DE. COM 21/09/10

CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Per

Malcolm Murphy

Director of Manufacturing Davenport Works

Terrence Thom

Quality Assurance Manager

1292289	0			
Ship Date	B.L. No.	Invoice No.	Alcoa No.	Item
2011-09-23	6372211	00000	1000300400-2	DCE-00400-2
P.O. No./Govt Contract No.	Customer	Alcoa Item		
C63906 Ln#: 2	SAMUEL SON & CO LT G041110647R06			

Page 1 of 2

Ship To: SAMUEL SON & CO LTD
S.S.M.Q
21525 CLARKE-GRAHAM
BAIE D'URFE H9X 3T5 QC

Item Description

0.063 IN TK (+0.0000 -.0035) X 48.0 IN W (+.125 - .125) X 144.0 IN LN (+.15625 -.15625) (N) A/T 6061-T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE GUARANTEED. AMS4027 REV N EXC MRK ASME-SB-209 REV 10 EXC MRK ASTM B209 REV 07 CMMPO25 REV S ((MARKED)) KRAFT PAPER INTERLEAVED MAX GROSS SKID WGT: 4500 LB QUAN TOL +/-30 % CQR 0222751 REV 05 CUST REQ 11-08-06 *** W/E 11-08-20 ***

5/21/06

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector	Clock Numbers
1	340127	719924	4033	100	PC	27592	46940
2	340135	719924	4075	100	PC	27592	46940
			8108	200			

Notes for CQR: 0222751.5

PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISIO N DATED 1997-08-01.

CQR: 0222751.5 -Specification Limits

Temp	Dir	UTS	TYS	EL4D
		KSI	KSI	PCT
T6	Long Transv.	Max		
		Min	42.0	35.0 10

CERTIFIED INSPECTION REPORT

Alcoa Inc.

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Per:

Malcolm Murphy

Malcolm Murphy
Director of Manufacturing Davenport Works

Terrence Thom

Terrence Thom
Quality Assurance Manager

1292289

0

Ship Date

B.L. No.

Invoice No.

Alcoa No. Item

2011-09-23

6372211

00000

1000300400-2

DCE-00400-2

P.O. No./Govt Contract No.

Customer

Alcoa Item

C63906 Ln#: 2

SAMUEL SON & CO LT 0041110647R06

Page 2 of 2

CQR: 0222751.5 -Specification Limits (cont.)

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other		Total Aluminum
										Each	Other	
	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15	
Alloy 6061	Min	0.40		0.15		0.8	0.04					

Lot: 719924 - Mechanical, Physical, Metallography, Quantometer Results

Tmpr	Dir	Test	No->		UTS	TYS	EL4D
			KSI	PCT			
T6	Long Transv.	2	50.2	44.5	11.6		
			50.2	44.3	11.7		

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H2797021	Actuals	0.64	0.4	0.23	0.04	1.0	0.16	0.02	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States